LGHS-077

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INSTRUCTIONS FOR COMPLETING DD FORM 1423

(See DoD 5010.12M for detailed instructions.)

FOR GOVERNMENT PERSONNEL

- Item A. Self-explainatory.
- Item B. Self-explainatory.
- Item C. Mark (X) appropriate category: TDP Technical Data
 Package; TM Technical Manual; Other other category of data,
- such as 'Provisioning', 'Configuration Management', etc.
- Item D. Enter name of system/item being acquired that data will
- Item B. Self-explainatory (to be filled in after contract award).
- Item F. Self-explainatory (to be filled in after contract award).
- Item G. Signature of preparer.
- Item H. Date CDRL was prepared.
- Item I. Signature of CDRL approval authority.
- Item J. Date CDRL was approved.
- Item 1. See DoD FAR Supplement Subpart 4.71 for proper numbering.
- Item 2. Enter title as it appears on data acquisition document cited in Item 4.
- Item 3. Enter subtitle of data item for futher definition of data item (optional entry).
- Item 4. Enter Data Item Description (DID) number, military specification number, or military standard number listed in DoD 5010.12-L (AMSDL), or one-time DID number, that defines data content and format requirements.
- Item 5. Enter reference to tasking in contract that generates requirement for the data item (e.g. Statement of Work paragraph number).
- Item 6. Enter technical office responsible for ensuring adequacy of the data item.
- Item 7. Specify requirement for inspection/acceptance of the data item by the Government.
- Item 8. Specify requirement for approval of a draft before preparation of the final data item.
- Item 9. For technical data, specify requirement for contractor to mark the appropriate distribution statement on the data (ref DoDD 5230.24).
- Item 10. Specify number of times data items are to be delivered.
- Item 11. Specify as-of date of data item, when applicable.
- Item 12. Specify when first submittal is required.
- Item 13. Specify when subsequent submittals are required, when applicable.
- Item 14. Enter addresses and number of draft/final copies to be delivered to each addressee. Explain reproducible copies in Item 16.
- Item 15. Enter total number of draft/final copies to be delivered.
- Item 16. Use for additional/clarifying information for items 1 through 15. Examples are: Tailoring of documents cited in Item 4; Clarification of submittal dates in Items 12 and 13; Explanation of reproducible copies in Item 14; Desired medium for delivery of the data item.

FOR THE CONTRACTOR

- Item 17. Specify appropriate price group from one of the following groups of effort in developing estimated prices for each data item listed on the DD Form 1423.
- a. Group I. Definition Data which is not otherwise essential to the contractor's performance of the primary contracted effort (production, development, testing and administration) but which is required by DD Form 1423.

Estimated Price - Costs to be included under Group I are those applicable to preparing and assembling the data item in conformance with Government requirements, and the administration and other expenses related to reproducing and delivering such data items to the Government.

b. Group II. Definition - Data which is essential to the performance of the primary contracted effort but the contractor is required to perform additional work to conform to Government requirements with regard to depth of content, format, frequency of submittal, preparation, control, or quality of the data item.

Estimated Price - Costs to be included under Group II are those incurred over and above the cost of the essential data item without conforming to Government requirements, and the administrative and other expenses related to reproducing and delivering such data item to the Government.

c. Group III. Definition - Data which the contrator must develop for his internal use in performance of the primary contracted effort and does not require any substantial change to conform to Government requirements with regard to depth of content, format, frequency of submittal, preparation, control, and quality of the data item.

Estimated Price - Costs to be included under Group III are the administrative and other expenses related to reproducing and delivering such data item to the Government.

d. Group IV. Definition - Data which is developed by the contractor as part of his normal operating procedures and his effort in supplying these data to the Government is minimal.

Bstimated Price - Group IV items should normally be shown on the DD Form 1423 at no cost.

Item 18. For each data item, enter an amount equal to that portion of the total price which is estimated to be attributable to the production or development for the Government of that item of data. These estimated data prices shall be developed only from those costs which will be incurred as a direct result of the requirement to supply data, over and above those costs which would otherwise be incurred in performance of the contract if no data were required. The estimated data prices shall not include any amount for rights in data. The Government's right to use data shall be governed by the pertinent provisions of the contract.

	REVISION:	02						E	ENGINEERING DATA LIST	LIST	4	* HISTORY *	
DATE	E: 08FEB02	DATA TECH:	STJ	0	ORGN SYMBOL:	YMBC	T:	197 	LGMPM PR NR:		APPLICATION: F15	PAGE 1 OF 1	
CAGE: 76301	E: MANUFACTÜRER NAME 11 BOEING	JRER NAME:					12 % 12 %	REFERENCE 68A412704-10	REFERENCE NR: 68A412704-1004	NOUN: PISTON,LAN	NOUN : PISTON,LANDING GEAR	NSN : 1620014451436	
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STA	STANDARD ENGINEERING TEXT	NG TEXT											

ALL GOVERNMENT/MILITARY SPECIFICATIONS AND STANDARDS WILL NOT BE FURNISHED. TO OBTAIN THESE SPECS AND STDS WRITE TO:

BUILDING 4/SECTION D 700 ROBINS AVE.

PHILADELPHIA PA. 19111-5098 TELEPHONE: (215) 697-2179

FAX: (215) 697-1462 TO VIEW OR ORDER: HTTP://WWW.DODSSP.DAPS.MIL

ENGINEERING DATA LIST REMARKS

- C CLASSIFIED DOCUMENT. S FURNISHED WITH SOLICITATION. M STABLE BASE DRAWING REQUIRED; FURNISHED WITH CONTRACT AWADD FURNISHED METHOD CODE LEGEND:
- R FURNISHED BY PCD UPON REQUEST.
 P PARTIAL DOCUMENT FURNISHED.
 V VENDOR DRAWING;
- O OTHERS, CONTRACTOR MUST ACQUIRE. A DATA NOT AVATTABLE

G - GOV'T DOCUMENT.

X - DATA SUPPLIED (NOT IN EDCARS).

REV: -	ENGIN	IEERING DATA REQUIREMENTS (ATTACHMENT "A")				
NOTE: MILITARY SPECIFICATIONS USTAN 1. THE FOLLOWING INSTRUCTIONS ARE F	IDARDS WILL NOT BE FURNISHED IN THE BID SET.					
PISTON ASSEMBLY M		F-15				
2. PART NUMBER		3. NATIONAL STOCK NUMBER				
68A412704-1004		1620-01-445-1436				
4. THE FOLLOWING SPECIFICATIONS/STA	NOARDS, ETC., WILL BE USED IN LIEU OF THE DATA INDICATED. TH	IE SUPERSEDED DATA WILL NOT BE FURNISHED UNLESS S	O INDICATED.			
_	n engineering retains all rights to review I major, from the engineering drawing pa		=			
and standards called out a responsible to completel	ed, the contractor will certify to the government required for the manufacture of this cay search these manuals, specifications, are components. Any questions can be forward.	contracted landing gear component/ nd standards and fully understand th	assembly. Contractor is e requirements necessary to			
c. Inspection requirements are as follows:						
Class A, with the foll ALLOWED" is that The inspector perform as specified in MIL-S	1. Perform fluorescent penetrant inspection per ASTM E1417, Type I, Method B or C, Level 3 or 4, in lieu of PS 21202 Class A, with the following acceptance/rejection criteria: NO DEFECTS ALLOWED. The intent of "NO DEFECTS ALLOWED" is that the inspection is conducted at the required sensitivity level and there shall be no indication allowed. The inspector performing the inspection shall be certified to level II with the inspection procedures developed by a level III as specified in MIL-STD-410. 2. Perform Magnetic Particle inspection per ASTM E1444, in lieu of PS 21201 CLASS B. Use full wave direct current					
(FWDC), wet continu ALLOWED. The into level and there shall b	nous method, fluorescent type with the forent of "NO DEFECTS ALLOWED" is the no indications allowed. The inspector ares developed by a Level III as specified	llowing acceptance/rejection criteri that the inspection is conducted at the performing the inspection shall be of	a: NO DEFECTS ne required sensitivity			
d. Mark and identify per MIL-STD-130 as an alternate to PS16001. (ref. note #19)						
e. Heat treat to drawing	e. Heat treat to drawing specifications per MIL-STD-6875 as an alternate to PS 15296 or PS 15351.					
(with vibrating pneumat a location, OO-ALC/LII serialization shall begin of manufacture, followed contracts shall start seria	and components utilize the following static pencil), in 0.09" letters 0.004"-0.007". E shall provide S/N location instructions with the cage (FSCM) of the contractor nd by a dash and a sequentially unique 3 dilization of item with the next number in suber should begin using 4 digit serial number	deep in the location indicated. If the second of item shall be accommed on the contract, followed by a light number. A contractor who reconsequence of the prior contract. If a	the drawing does not indicate complished as follows: the a dash and the 2 digit year eives numerous intermittent contract produces more than			
	I to 180KSI and above, any surface grounds per MIL-STD-867. Grinding shall be p		e inspected for abusive			
h. Temper Etch per MI	L-STD-867 may be used as an alternate to	o PS 21205.				
i. Cadmium Plate per M	fIL-STD-870 Type II, Class 2 as an alter	nate to PS 13144 13101 & PS 1314	14.			
PREPARED BY		SYMBOL	DATE			
TERRY L. JONES		LGMPM	19 Nov 01			
OO.ALC FORM 462 OCT 96	/EE V/1/m-ronu nno:	DECUMPLE EDITIONS ARE OPEN ETT	huor or			

REVi	ENGINEERIN	G DATA REQUIREMENTS CONTINUATION SHEET
		(ATTACHMENT "A")
PART NUMBER		NATIONAL STOCK NUMBER
68A412704-1004		1620-01-445-1436
j. Chromium Plate per M	IIL-STD-1501, Type II, Class 3 as an a	alternate to PS 13102.
k. Install bushings per	the following in lieu of PS 17034.	
housing into which the installations, such as	ne bushing is installed, or the finish of t	manner as to avoid damage to the finish on the I.D. of the the O.D. of the bushing. Forced installation of sub-zero rmitted, and is not acceptable. A small nonmetallic hammer ag bore, or to seat the bushing.
b. Prior to bushing contamination.	installation, the parts and housing bore	shall be cleaned with a cleaning solvent to remove all
by OO-ALC/LILEC		is unless some other sub-zero coolant is specified, and approved hing in the liquid nitrogen shall be sufficient to allow the bushing
	shall be accomplished as necessary to	ely upon removal from the coolant with an absolute minimum of minimize installation time which should be in the order of about
cooling of the bushir heating, the parts sha maximum temperatu	ng. Detail parts in process, which do not all be heated by the use of radiant heat the re of 250 F. The temperature measuring	o which the bushing is to be installed, in addition to sub-zero of have paint or sealant or other organic material applied prior to techniques, such as thermal blankets, infrared lamps etc.; to the ng devices shall be used to monitor heat and shall be located on No scaling, oxidation, or corrosion shall be permitted.
•	-	bore which has received a light coat of sealant per MIL-S-81733. at may have extruded around the periphery of both ends of the
or lug under flange flange when bushing	Sealant shall be applied in such a mar is installed. Wipe off any excess sealar	nner as paragraph (F) except sealant shall also be applied to face nner as to ensure complete coverage of inside face of bushing nt amount periphery of bushing flange forming a bead. Wipe ng a bead. Wipe any excess sealant from other end of bushing
_	h external grease grooves the inside of of lug will be coated with MIL-S-8173	the lug will be coated with MIL-C-16173 prior to bushing 3 per paragraph g.
a. Apply one coat ep primer per MIL-PRF		85582, Type I Class 2. Alternate one coat of epoxy polyamide olyurethane per MIL-PRF-85285, Type I, color number 17925 has been cancelled.
m. Shot Peen per SAE are complied with.	AMS-S-13165 as an alternate to PS 140	223. (Insure all requirements of drawing 68A412704 note #27

SYMBOL

LGMPM

DATE

19 Nov 01

PREPARED BY

TERRY L. JONES

REV: .	ENGINEERING I	DATA REQUIREMENTS CONTINUATION SHEE (ATTACHMENT "A")	Т
PART NUMBER		NATIONAL STOCK NUMBER	
68A412704-1004		1620-01-445-1436	
n. Phosphate Coat per MIL-P-16232 as an alter	nate to PS 13205.		
o. Ion Vapor Deposit Aluminum (IVD) per MII	L-C-83488 as an a	Iternate to PS 13143.	
p. Anodize per MIL-A-8625 Type II, Class 1, a	as an alternate to F	PS 13201.	
q. Grind per MIL-STD-866 as an alternate to P	S 20710.		
r. Bearing General specification Qualifications	MIL-B-81934 has	been cancelled use SAE AS 819	34
s. QQ-C-530 condition "H" can be used as an a	liternate to PS1593	3.	
5. The required forging will be procured from dies/tooling.	the qualitied forgi	ng source using the original certif	fied forging procedures and
a. Prior to contract award the detail part bide certified dies and forging procedures are available provide forgings for their use in the event they a	ole and that the for	ging source has an agreement wi	rce, to the government that the th the detail part bidder to
b. Prior to production, forging lot qualificate. The contractor will assure that this is or has bee accomplishment to the Government. Ultrasonic	n accomplished by	the forging source and will subr	
FORGING SOURCE, CONTROL AND LO	CATION OF DIES	S:	
1. FORGING DRAWING:			
Drawing Number: Part Number	68A412704 68A412704-10)	
Die Number:	7782	,004	
2. CONTROL OF FORGING PROCESS:	McDonnell Do	ouglas	
3. LOCATION OF FORGING DIES:	Kropp Forging 5301 West Ro Cicero, Illiono (708) 652-669	osevelt Road	
PREPARED BY		SYMBOL	DATE
TERRY L. JONES		LGMPM	19 Nov 01

SOURCE QUALIFICATION REQUIREMENTS

(PL98-525, SECTION 2319)

STOCK NR (NSN)1620014451463

NOUN: Piston Assembly, Main Landing Gear

PART NUMBER (P/N)68A41d2704-1004 AIRCRAFT:F-15E

SECTION C

QUALIFICATION REQUIREMENTS THAT MUST BE SATISFIED TO BECOME A QUALIFIED SOURCE:

- 1. Because of the need for uninterrupted item support to military aircraft systems while keeping with the requirements of PL 98-525, the current acquisition need not and generally will not be delayed to provide an offeror an opportunity to qualify. Normal acquisition practices at OO-ALC should preclude the denial of opportunity to any interested offeror.
- 2. The offeror must provide a pre-contract award qualification article, which meets the requirements of the engineering drawings, material specifications, and process specifications. However, successful completion of the qualification testing does not guarantee any contract award. If the offeror is deemed qualified and awarded the contract, a post-contract award first ariticle exhibit may be required to verify production capability.
- 3. The qualification article will be subjected to form, fit, and function verification as well as required testing to assure compliance with data list and other applicable procurement criteria. The qualification article shall demonstrate full compatibility and comparability with existing parts.
- 4. The required materials will be procured from a qualified source and shall meet the requirements of their respective specifications. The offeror will assure that the supplier has accomplished this and shall submit certified documentation of accomplishment of the above requirements to the purchaser along with the pre-contract award qualification article.
- 5. The required forgings shall be procured from the qualified forging source using the original certified forging procedures and dies. Forging material and lot qualifications shall be accomplished as required in the specified forging drawing, P/N <u>68A41d2704-1004</u> and specification <u>SAE-AMS-7190</u>. The offeror shall assure that this is or has been accomplished by the forging source and will submit certified documentation of accomplishment of the above requirements to the government along with the pre-contract award qualification article.
- 6. The qualification article once submitted will become subject to such testing as deemed necessary by the U.S. Government to prove that the article meets all dimensional, processing and functional requirements. Such testing may result in the destruction of the article. Following completion of necessary testing and evaluation, the article no matter what its condition shall be returned to the contractor or disposed of at his discretion and direction whether it was found acceptable or not.
- 7. Form verification: The U.S. Government's Quality Verification Center (QVC) will be used to insure compliance with the dimensional requirements of the article. Material and processing compliance will also be verified as required.
- 8. Fit/function verification: Existing components and government test stands and fixtures will be utilized to verify physical interface and functional performance of articles.
- 9. Testing for material and process compliance.

(a) Material analysis

(e) Finish

(b) Heat treat

(f) Grain flow

(c) Grinding

(g) Other

(d) Plating

SOURCE QUALIFICATION REQUIREMENTS

(PL98-525, SECTION 2319)

STOCK NR (NSN)1620014451463

PART NUMBER (P/N)<u>68A41d2704-1004</u> AIRCRAFT:F-15E

NOUN: Piston Assembly, Main Landing Gear

10. Remarks:

- a. Organic verification capabilities exist at OO-ALC.
- b. Testing requirements outside organic capabilities will be contracted out.
- 11. The estimated cost of government testing and evaluation is \$30,000.
- 12. Maximum time for testing of the qualification article will not exceed 30 days from receipt at testing agency.

SECTION D

QUALIFICATION WAIVER REQUIREMENTS.

- 1. An offerer who has had previous experience in the manufacture and qualification of items, which can be correlated with this product, may apply to the design control authority at OO-ALC for a waiver of the above stated qualification requirements.
- a. The qualification waiver criteria utilized by the design control authority to perform a qualification analysis are available upon request. The qualification waiver criteria may be used as a guide in preparing the offerer's written input to the design control authority.
- b. The burden of proof for written inputs is on the offerer. The design control authority will not pursue authenticity verification of claims made by the offerer of product manufacturing experience with other Government or non-Government agencies. Unsubstantiated claims will not be considered in the waiver analysis process.
- c. This waiver will be granted if and only if the design control authority (LILE) can establish the qualifications of the offerer through the evaluation of written inputs from the offerer or from previous knowledge of the offerer's capabilities or from previous experience with the offerer on similar item acquisitions. If there is any doubt about the offerer's capability, the offerer will be required to submit a pre-qualification article. There is no guarantee of qualification by similarity. LILE reserves the right to require a pre-qualification article of all offerers.
- 2. The current acquisition need not and will not be delayed in order to provide an offerer with an opportunity to meet the requirements for qualification waiver.
- 3. Maximum time for approval of qualification by similarity will not exceed 15 days.

SPECIAL PAC	CKAGING INSTRUCT	ION	CODE ID 98747	SPI NO. (TPO) F01-235-2271
				SHEET 1 OF 3
PART OR DRAWING NO. 68A412704-1002	NATIONAL STOCK NO. 1620-01-235-2271	CURRENT RE V A	ILL. T. LUCE	
ITEM NOME PISTON, M	NCLATURE 1LG, F-15	DRIGINAL DATE 95131	ENGR, M. STEF	PHENS
MILITADY DDECEDVATIO	N. TANZ MIL CED 2072		COCCICIED DELL	TALL DE MATERIALS

MILITARY PRESERVATION IAW MIL-STD-2073

SERVICEABLE METHOD: 20

UNSERVICEABLE METHOD: 20

QUP 001
ICQ 000

CLEANING & DRYING: IAW MIL-STD-2073 PRESERVATIVE: MIL-PRF-16173, GR2

MARKING IAW MIL-STD-129

SPECIAL MARKINGS:
A) SPI NO. F01-235-2271

*MARK THE SPI NUMBER ON ONE SIDE OF THE CONTAINER AND ON ALL REMOVABLE DUNNAGE.

CLOSURE

LEVEL A: IAW: ASTM-D6251 LEVEL B: IAW: ASTM-D6251 PACKING AS SPECIFIED BELOW AND BILL OF MATERIALS STYLE TYPE CL VRTY GR TR SPEC LEVEL Α 2 В ASTM-D6251 III A1 В Α ASTM-D6251 IIIA1 1 LEVEL A LEVEL B

GROSS CU FT 11.156 11.156 GROSS WT LBS 166.80 166.80 110 110 DESIGN FRAGILITY G DEPTH LENGTH WIDTH CNTR I.D. 49 19 12 1/2 CNTR D.D. LEVEL A 18 51 21 18 LEVEL B 51 21 ITEM DIM 45 14 1/2 9 1/2 ITEM WT LBS 88

	RE VISIONS	
LTR	DESCRIPTION	DATE
Α	UPDATED, ADDED WOOD STATEMENT	03105

1					_
- 4	1	CUSHION (CENTER)	49 X 19 X 8	MIL-PRF-26514 TYPE 1, CLASS 1, GR A, FIN 1	
-3	2	CUSHIONS (TOP & BOTTOM)	49 X 19 X 2	MIL-PRF-26514 TYPE 1, CLASS 1, GR A, FIN 1	∫⊆
-5	1	WRAP	50 X 50	A-A-3174, TYPE I, CLASS 1, GRADE A, FIN 1	15
-1	3	SKIDS	21 X 4 (NOM) X 4	ASTM-D6199 CLASS 2, GROUP 1	
P/N	QTY REQD	N⊡MENCLATURE DESCRIPTION	SIZE (INCHES UNLESS SPECIFIED)	MATERIAL SPECIFICATION REVISIONS	[[]]

PI NO. F01-235-2271

SPECIAL PACKAGING INSTRUCTION	СПDE ID 98747	SPI NO. (TPO) F01-235-2271
ITEM NOMENCLATURE PISTON, MLG, F-15		SHEET 2 OF 3

EUROPEAN UNION (EU) REQUIREMENTS NOTICES

NOTICE 1: LUMBER AND PACKAGING/CONTAINER STATEMENT — "ALL WOODEN LUMBER CONTAINERS PRODUCED ENTIRELY OR IN PART OF NON-MANUFACTURED SOFTWOOD SPECIES SHALL BE CONSTRUCTED FROM HEAT TREATED (HT) MATERIAL (HT TO 56 DEGREES CENTIGRADE OR 133 DEGREES FAHRENHEIT FOR 30 MINUTES). CERTIFICATION IS REQUIRED BY AN ACCREDITED AGENCY RECOGNIZED BY THE AMERICAN LUMBER STANDARDS COMMITTEE (ALSC). CONSTRUCTION AND CERTIFICATION SHALL BE IN ACCORDANCE WITH NON-MANUFACTURED WOOD PACKING POLICY AND NON-MANUFACTURED WOOD PACKING ENFORCEMENT REGULATIONS, BOTH DATED MAY 30, 2001." THESE DOCUMENTS CAN BE FOUND AT WWW.APHIS.USDA.GOV.

NOTICE 2: WOODEN PALLET STATEMENT — "ALL WOODEN PALLETS PRODUCED ENTIRELY OR IN PART OF NON-MANUFACTURED SOFTWOOD SPECIES SHALL BE CONSTRUCTED FROM HEAT TREATED (HT) MATERIAL (HT TO 56 DEGREES CENTIGRADE OR 133 DEGREES FAHRENHEIT FOR 30 MINUTES). CERTIFICATION IS REQUIRED BY AN ACCREDITED AGENCY RECOGNIZED BY THE AMERICAN LUMBER STANDARDS COMMITTEE (ALSC). CONSTRUCTION AND CERTIFICATION SHALL BE IN ACCORDANCE WITH NON-MANUFACTURED WOOD PACKING POLICY AND NON-MANUFACTURED WOOD PACKING ENFORCEMENT REGULATIONS, BOTH DATED MAY 30, 2001." THESE DOCUMENTS CAN BE FOUND AT WWW.APHIS.USDA.GOV.

NOTICE 3: HARDWOOD SPECIES STATEMENT - "ALL WOODEN PALLETS PRODUCED ENTIRELY OF NON-MANUFACTURED HARDWOOD SPECIES SHALL BE IDENTIFIED BY A PERMANENT MARKING OF "NC" (NON-CONIFEROUS), 1.25 INCHES OR GREATER IN HEIGHT, ACCOMPANIED BY THE CAGE CODE OF THE CONTRACTED MANUFACTURER AND THE MONTH AND YEAR OF THE CONTRACT. ON PALLETS, THE MARKING SHALL BE APPLIED TO THE STRINGER OR BLOCK ON OPPOSITE SIDES AND ENDS OF THE PALLET AND BE CONTRASTING AND CLEARLY VISIBLE."

NOTES:

- 1. USE MIL-C-16173, GRADE 2 DN CRITICAL SURFACES, WRAP ENTIRE ITEM IN REF.-2.
- 2. CUT REF.-4 TO SHAPE OF PISTON CENTERED ON CUSHION, PLACE WRAPPED ITEM INTO CUT OUT. REF.-4. INSERT INTO CONTAINER AS ILLUSTRATED.
- 3. SKIDS INSET ONE INCH EACH END WITH SKIDS RUNNING THE WIDTH OF THE CONTAINER, CENTER SKID.

SPECIAL PACKAGING INSTRUCTION	CODE ID 98747	SPI NO. (TPO) F01-235-2271
ITEM NOMENCLATURE PISTON, MLG, F-15		SHEET 3 OF 3
-2 TITEM REFERENCE		-3